

Work Order ID 84621

May-17-12 10:40:37 AM

84621

Page 1

Item ID: D130-700-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bearpaw

Stop

NS2

Start Date: 17/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/05/17 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3167	Rev A1

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D130-700-011CHG001

JB 8/26/10

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

JP

2

12/07/10 JB

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

8/26/10

(JP)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84621

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Page 2

May-17-12 10:40:37 AM

Item ID: D130-700-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw

Stop ***NS2***

Start Date: 17/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00				2x			SP
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D130-700-011 Location: _____								12-7-10
		Rev A							
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							12/7/12
Quality Control									

12-07-11

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-17-12 10:40:41 AM

Page 1

Work Order ID: 84621

84621

Parent Item: D130-700-011

D130-700-011

Parent Item Name: Bearpaw

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3167-1		Manufactured	No				Each	1.0000					
---------	--	--------------	----	--	--	--	------	--------	--	--	--	--	--

D3167-1

Bearpaw

Location

Loc Qty

Loc Code

ST495

1

43828

1

AN4-12A

Purchased

No

170

Each

648.0000

AN4-12A

Bolt

Location

Loc Qty

Loc Code

ST357

648

115422

4

119775

50

120423

569

121524

25

AN4-15A

Purchased

No

170

Each

591.0000

AN4-15A

Bolt

Location

Loc Qty

Loc Code

358

100

121652

100

GA

100

120449

100

ST358

391

118706

3

120422

88

121444

100

121541

200

Qty per Kit: 4
Total Qty: 84613
Qty Issued: [Signature]
Date Issued: [Signature]

Qty per Kit: 8
Total Qty: 121524
Qty Issued: 23
Date Issued: [Signature]

Qty per Kit: 16
Total Qty: 122141
Qty Issued: 21
Date Issued: 12/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

May-17-12 10:40:41 AM

Page 2

Work Order ID: 84621

84621

Parent Item: D130-700-011

D130-700-011

Parent Item Name: Bearpaw

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 2.00

Required Qty: 2.00

AN960JD416 NAS1149D0463J Purchased No

170 Each

30.0000

12

24

✓

**

121912 JB



AN960.ID416

Washer

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

170

Each

0.0000

4

8

✓

**

73932 JB



D2182B060 Manufactured No

D2182B060

Clamp Cushion

D2274

Manufactured No

170

Each

376.0000

12

24

✓

**

84199 JB



D2274

Radius Block

Location

Loc Qty

Loc Code

ST007

376

78233

2

81958

164

83258

210

170

Each

11.0000

4

8

✓

**

JB 12/07/10

D2519

D2519

Clamp

Location

Loc Qty

Loc Code

ST459

11

73499

11

73499

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 84621

Parent Item: D130-700-011

Parent Item Name: Bearpaw

84621

D130-700-011

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 2.00

Required Qty: 2.00

D2529

Manufactured No

170

Each

763.0000

12

24

**

D2529

Washer

Location

Loc Qty

Loc Code

ST010

763

79485

18

81873

245

84435

500

11 x 8/873

3 x 84435

D3171-1

Manufactured No

170

Each

9.0000

4

8

**

D3171-1

Angle

Location

Loc Qty

Loc Code

ST031

9

81618

9

81618

MS21042L4

Purchased No

170

Each

4,686.000

12

24

**

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

4686

119075

153

121011

1270

121444

2963

121652

300

121444

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

NO COPY ISSUED

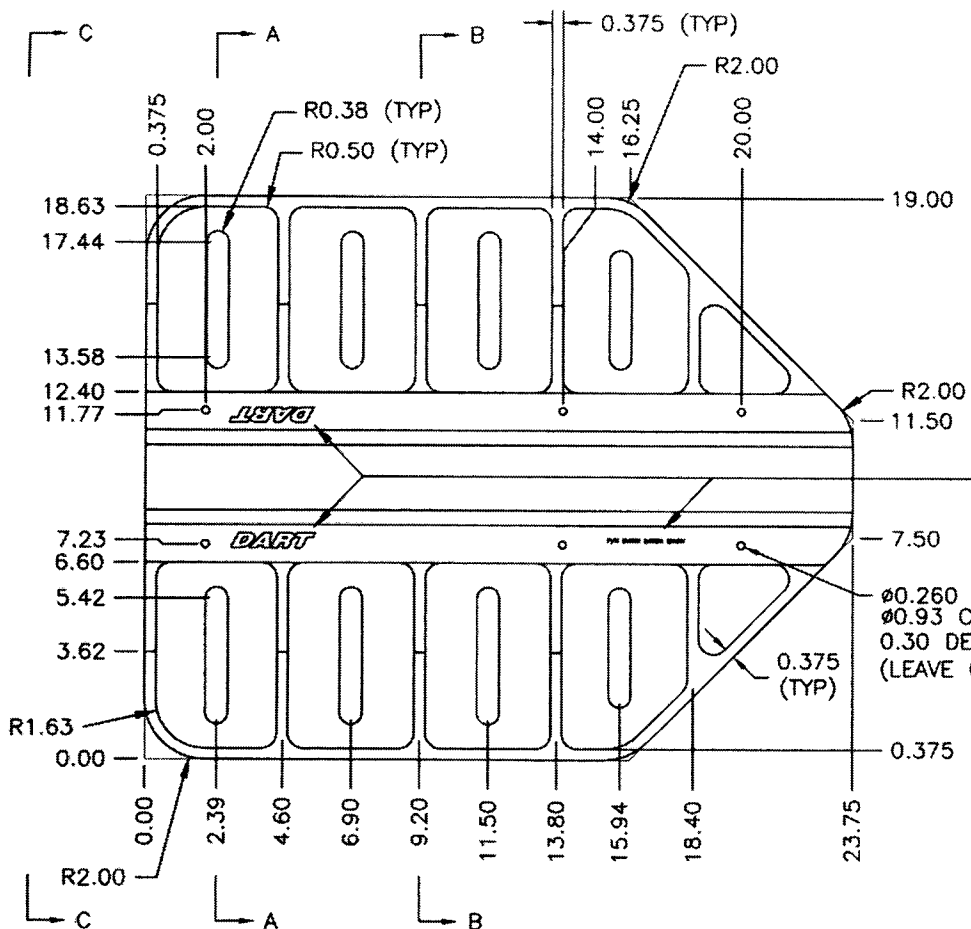
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CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3167	SHEET 1 OF 2
02.10.08		TITLE	SCALE
		BEARPAW	1:6
A	02.10.08	NEW ISSUE	
A1	02.12.17	5:30 WAS 5:50	

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84621 MW

WORK ORDER
NO. 84621 MLJ

ORDER
21 MLT
12/05/17



D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

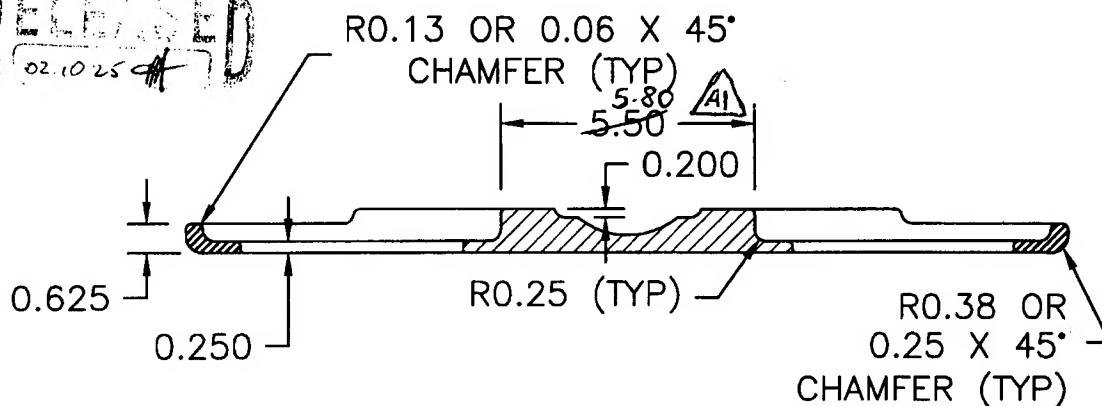
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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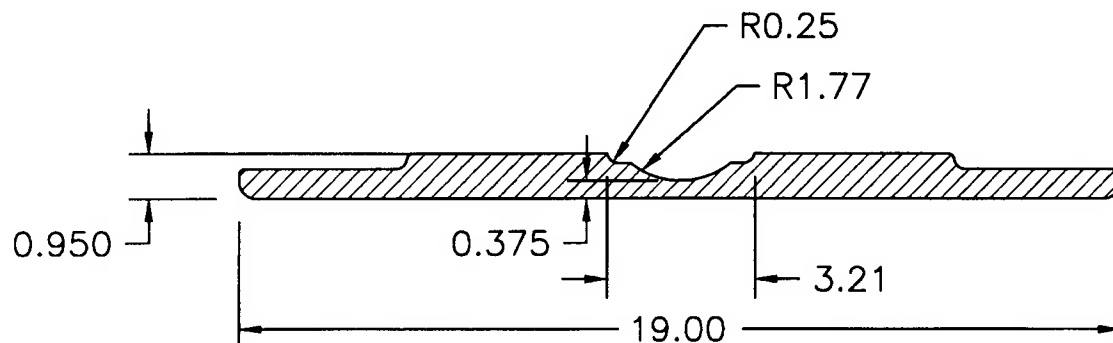


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

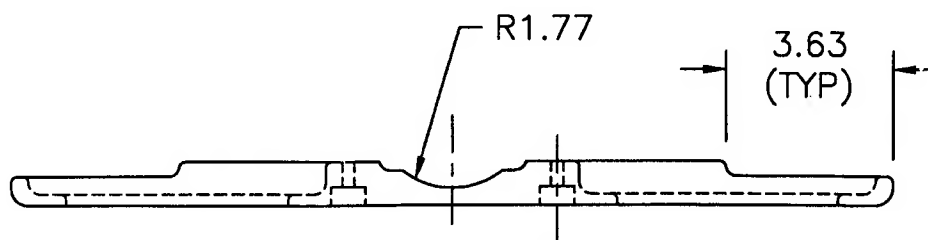
RELEASED
02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

84621

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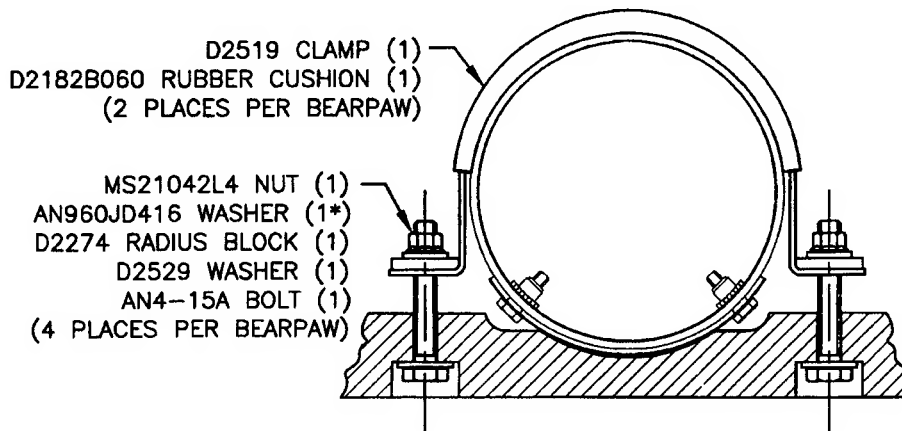
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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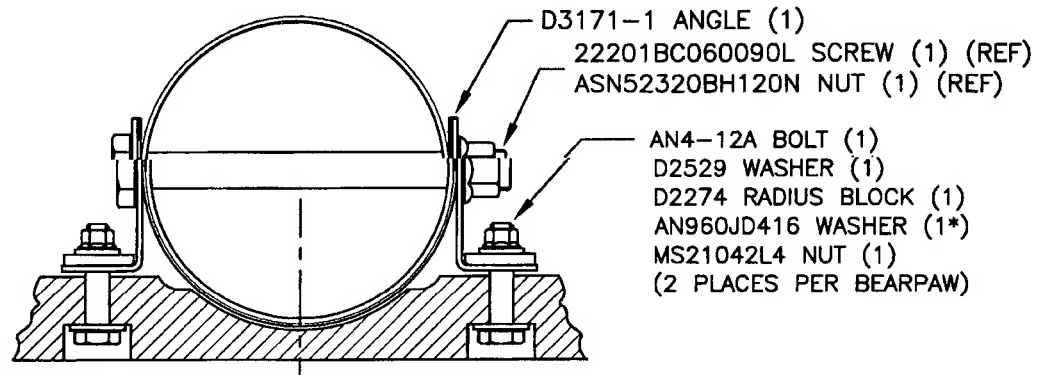
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NOTE: Date & initial all entries



*See note 6

Figure 3 - Clamping Detail (Forward Clamps)



*See note 6

Figure 4 - Clamping Detail (Aft Clamps)

5. PARTS LIST

Qty	Part Number	Description
X	D130-700-011	BEARPAW INSTALLATION
4	D2182B060	Rubber Cushion
12	D2274	Radius Block
12	D2529	Washer
4	D2519	Clamp
2	D3167-1	Bearpaw
4	D3171-1	Angle
4	AN4-12A	Bolt
8	AN4-15A	Bolt
12	AN960JD416	Washer
12	MS21042L4	Nut (or MS21042-4)

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Revision: A

Date: 02.10.08